

Date: Thursday, 17/07/2008 1:36:10 PM
User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: UPPER BLADE SUPPORT ASSY
Job Number	: 40597		
Estimate Number	: 13471		
P.O. Number	:	Part Number	: PB674300175
This Issue	: 17/07/2008 S.O. No. :	Drawing Number	: B6743001 P.11
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	:	Material	:
Written By	:	Due Date	: 24/07/2008 Qty: ⁶ / ₁₀ Um: Each
Checked & Approved By	: <u>mf 08-07-17</u>		
Comment	: Est Rev:A 08-07-17 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001167	Long Side Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Long Side Plate

batch: B40028

mf 08-07-17 6

2.0	PB6743001169	Long Support Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Long Support Plate

batch: B40029

mf 08-07-17 6

3.0	PB6743001171	Mounting Plate
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Mounting Plate

batch: B37670

mf 08-07-17 6

4.0	D34501	Reinforcement Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Reinforcement Plate

batch: B39954

mf 08-07-17 6

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: Weld assembly as per dwg PB67-43001

mf 08-07-17 6

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Job Number: 40597

Part Number: PB674300175

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-07-18

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/21 (6)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

M102316

(6X)

1- put screws in nut plates before powder coating to keep thread clean

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:40
320°F
2:10

M-H 08/07/21

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FX 08/07/21 (6)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

S7510

PC 8/7/23 (6)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

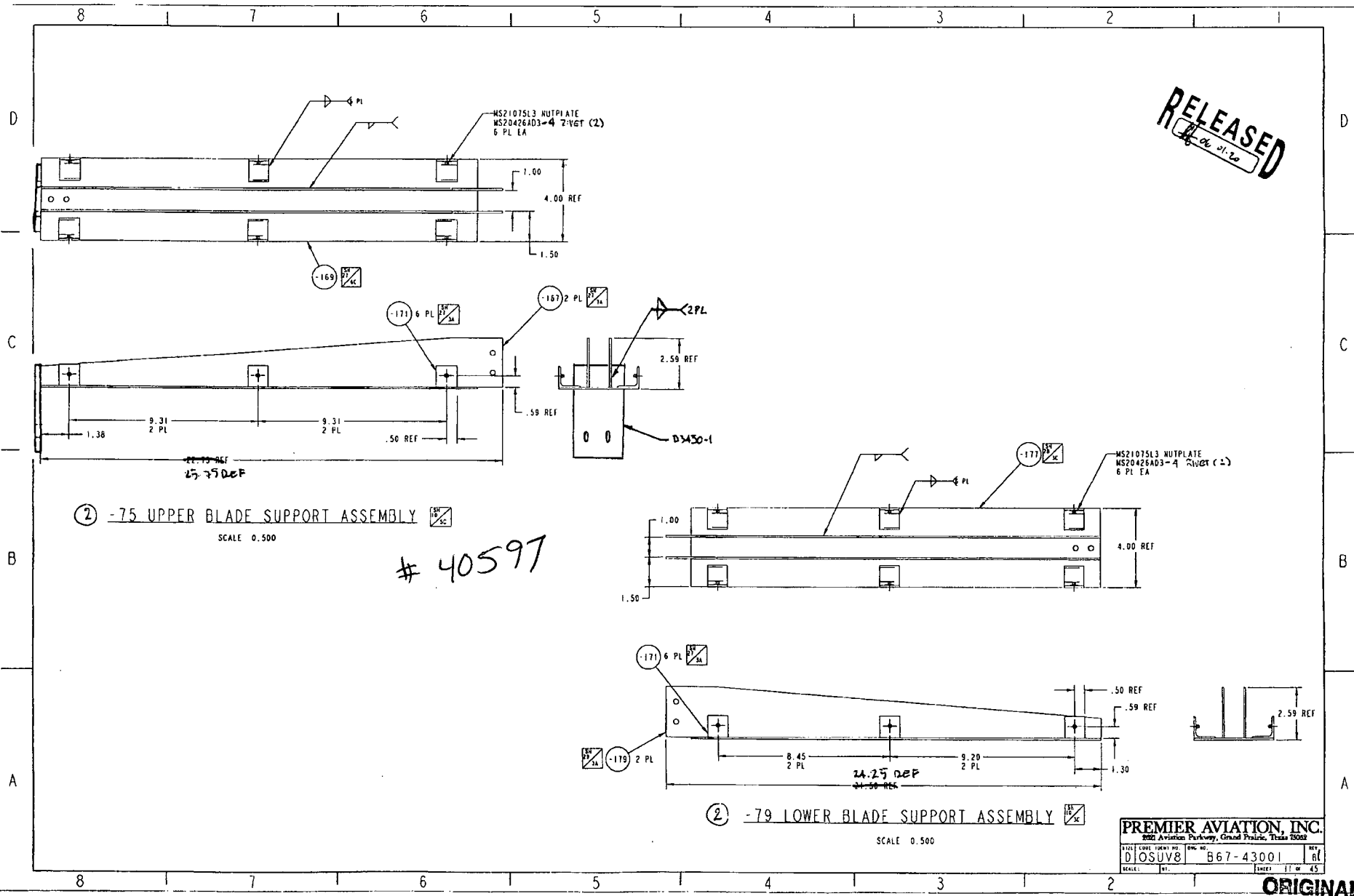
08/08/2011

Job Completion



U 08.08.19

RELEASED
40597



② -75 UPPER BLADE SUPPORT ASSEMBLY

SCALE 0.500

40597

② -79 LOWER BLADE SUPPORT ASSEMBLY

SCALE 0.500

PREMIER AVIATION, INC.			
2001 Aviation Parkway, Grand Prairie, Texas 75052			
SIZE	CODE	IDENT NO.	REV
D	10	867-43001	6A
DATE	BY	CHKD	11 10 45

ORIGINAL

DART AEROSPACE LTD		Work Order:	39932
Description: -75 Upper Blade Support Ass.		Part Number:	367-43001-75
Dwg: 367-43001	SHEET 11	Qty:	10 12
		Page of	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler			
cut	GA WJ	Long Support plate -169 use mat: 090 6061 T6 al. (m7950) cut 21.50" x 4.00" mark part for holes draw mark part drill holes as per dwg. deburr Batch: 40029 P36743001-169		08.06.26	1
2	GA WJ	Long side plate -167 use mat: 090 6061 T6 al. (m15120) cut 25.75" x 2.50" mark part cut at angle mark holes drill holes as per dwg. deburr Batch: 40028 P36743001-167		08.06.26	2
* 3	GA WJ	mounting plate -171 use mat: AND10133-1002 6061 T6 QA-A-200/2F AL. mat: 090 thk, 6061 T6 QA-A-250/11X125 cut 1"x1" mark holes for nut plate drill holes 1938 in center of 0.998 each side of hole 1/4" space each side. B37670=D6207		08.06.26	120
4	install GA	counter sink Holes as per dwg.		08/07/04	(120)
5	install GA	install nut plate (m521075L3N) (m16235) using nut m520426AD3-4 (m9748) to mounting plate - P367		08/07/10	6
6	Weld WA	weld parts -169 & -167 & -171 as per dwg. use 1" spacer (square tube) for gap between side plate -167 and main flange		08.01.19	
7	dim FR	chemical conversion as per part QSI 0054.1			
8	Paint FP	powder coat green smtex as per QSI 0054.1			
9	QC3	Inspect Powder Coat.			
10	BT	Identify & Stock			
11	@ DC	Label 21.			
		Close W/O			
16B	QC5/9	Inspect w/eld to Current Step		08.01.18	

Rev	Date	Change	Revised By	Approved

PRELIMINARY ISSUE